

Work Order ID 149495

Monday, July 25, 2016 10:53:17 AM

149495

Page 1

Item ID: D2665-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle, LH Fwd Aft Out

Start Date: 7/25/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 7/29/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference: touch up, return to stock

Approvals: Process Plan: *[Signature]* Date: *[Blank]*

Tooling: Date: *[Blank]*

Run Start ***NR1***

QC: *[Signature]* Date: *[Blank]*

SPC (Y/N): Date: *[Blank]*

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr Revision Nbr

D2665 Rev D

150 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 0.00

150

Powdercoat

Powder Coating

Memo

PULL FROM TRIAL FIT:
1 X D2665-1 B120551 *[Checkmark]*

TOUCH UP A/R

134798

START: 2:00

A.T: 3:00

FINISH: 2:00

(X) ✓

Md 16.08

1 16-11-22

160 QC3- Inspect Part Finish 0.00

160

QC

Quality Control

Memo

0.00

DAS 38 9-89

NOV 23 2016

170 Identify as per dwg & Stock Location: *ST402* 0.00

170

Packaging

Packaging

Memo

0.00

RE-IDENTIFY USING NEW B/N

1X

NOV 23 2016

DAS 38 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Work Order NCR

Reviewed
DQA:
Date:

Printed on: Thursday, August 18, 2016

Details			
Raised Date 8/18/2016	Status Open	Owner Maranda, Denis	Number NCR16-5986
Target Date 9/5/2016	Standard	Severity	
Process Inspection		Audit	
Raised By Person Duval, Patrick	Raised Against (Department or Supplier) Engineering	Fault Category General\Finish	
Details Saddles were use for trial fit by engineering. After trial fit completed saddles had little damage cause by the hardware getting in contact with the saddle and removing the powder coat and in some places the alodine was remove too. In order to fix this issue engineering decided to use white tough paint which turn out to be not acceptable by QC because of the variance in the colour. Parts and work order affected D2666-2 B149493, D2662-1 B149491, D2661-2 B149489, D2661-1 B149490, D2665-2 B149496, D2662-2 B149492, D2665-1 B149495. Picture attach			
Keywords		Product D206-642\D2666-1	
Document		Root Cause	
Closed By	Closed Date	Resolution	

Corrective Action			
Target Date 9/5/2016	Owner Downing, Eric M	Closed Date	Closed By
Details			

Actions			
Number	Owner	Target Date	Completed Date
Details			
1	Smith, Patrick	9/2/2016	
get approval to re powder coat saddles			
2	Sheldon, Andrew	9/2/2016	
after approval from DQA, strip saddles			
3	Roquebrune, Benoit	9/2/2016	
touch up alodine as required and powder coat as per QSI005 4.3			

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Item ID: D2665-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Saddle, LH Fwd Aft Out

Stop ***NS2***

Start Date: 7/25/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/29/2016 Req'd Qty: 1.00

1

Customer:

Reference: touch up, return to stock

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.02

Quality Control

16/11/24 *[Signature]*
DAS 21
88-6 12 9-89
NOV 24 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Picklist Print

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Page 1

Work Order ID: 149495

149495

Parent Item: D2665-1

D2665-1

Parent Item Name: Saddle, LH Fwd Aft Out

Start Date: 7/25/2016

Required Date: 7/29/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP: C00.11.01Removed P/O for Powder Coat - in house processEC
IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2665-1		Manufactured	No				Each	6.0000		1			

D2665-1

Saddle, LH Fwd Aft Out

**

ET 16 08-15

Location

Loc Qty

Loc Code

ST402

6

120551

1

135238

1

146083

4

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



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		OTHER : _____							

Linda Lacelle

From: Steven Drouin
Sent: Thursday, July 21, 2016 2:23 PM
To: Linda Lacelle
Subject: w/o for touch up paint

Hi Linda

I will need a w/o for paint touch up on these parts

D2661-2 x 2 B129615, B121702 — 149489
D2661-1 x 2 B141282 — 149490
D2662-1 x 2 B124309 — 149491
D2662-2 x 2 B129616 — 149492

D2666-2 x 2 B121591 B113167 — 149493
D2666-1 x 1 B109550 — 149494
D2665-1 x 1 B120551 — 149495
D2665-2 x 2 B136230 — 149496

And Aft Crosstube

D206-667-201 B140408 — 149497

Steven Drouin

Dart Aerospace

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Special Projects Coordinator
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Email: sdrouin@dartaero.com
Tel: 613-632-5200 ext. 240
Fax: 613-632-9311*

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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		OTHER : ☐							